

Work Order ID 72001

Friday, July 15, 2011 10:37:12 AM



Page 1

Item ID: D3686-041

Accept



Setup Start



Revision ID:

Stop



Item Name: MONOPOD ASSEMBLY

Start Date: 7/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-07-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3686

Rev D

100

Pick Kit

0.00



Packaging

Memo

0.00

Sb 1167/19

②

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

②

Small Fab

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent
on thread and assemble as per dwg D3686
ENSURE THERE IS ANTI-SEIZE ON FULL LENGTH OF THREAD*****

2-Assemble D3693-1 & D3691-1 & D3693-3 & D3688-7 Using Sikaflex -241/-
291 between mating surfaces as per dwg D3686
***Ensure holes for AN3C Bolts are free of sealant.
Torque Fastners as per Dwg D3686

Sb 1167/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/16/19

②

130

Identify as per dwg & Stock Location: 77

0.00



Packaging

Memo

0.00

Packaging

11/7/19 SP (2)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/20

mf

(1-07-19)

Dart Aerospace Ltd

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Picklist Print

Friday, July 15, 2011 10:37:18 AM

Page 1

Work Order ID: 72001

Parent Item: D3686-041

Parent Item Name: MONOPOD ASSEMBLY





Start Date: 7/15/2011

Required Date: 7/22/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3688-7  STUD		Manufactured	No			110	Each	2.0000	1	2			
<div> <div>Location</div> <div>GA</div> <div>50931</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3689-1  SLEEVE		Manufactured	No			110	Each	0.0000	1	2			
<div> <div>Location</div> <div>GA</div> <div>50931</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3691-1  STUD		Manufactured	No			110	Each	14.0000	1	2			
<div> <div>Location</div> <div>GA</div> <div>61370</div> <div>62181</div> </div> <div> <div>Loc Qty</div> <div>14</div> <div>3</div> <div>11</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3692-1  SPACER		Manufactured	No			110	Each	131.0000	4	8			
<div> <div>Location</div> <div>ST075</div> <div>51467</div> </div> <div> <div>Loc Qty</div> <div>131</div> <div>131</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

SB 11/07/19

2

SB 11/07/19

SB 11/07/19

1

SB 11/07/19

8

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 72001

Parent Item: D3686-041


Parent Item Name: MONOPOD ASSEMBLY

Start Date: 7/15/2011

Required Date: 7/22/2011


Start Qty: 2.00

Required Qty: 2.00

D3692-3	Manufactured	No	110	Each	15.0000	4	8
							
SPACER							


Location Loc Qty Loc Code


ST075 15
44690 15

D3693-1	Manufactured	No	110	Each	12.0000	1	2
							
Rod End Bearing							

Location Loc Qty Loc Code


GA 12
50734 12

D3693-3	Manufactured	No	110	Each	0.0000	1	2
							
Rod End Bearing							

AN3C10A	Purchased	No	110	Each	24.0000	2	4
							
Bolt							

Location Loc Qty Loc Code

ST351 24
105940 4
112489 20

AN3C12A	Purchased	No	110	Each	40.0000	2	4
							
Bolts							

Location Loc Qty Loc Code

ST351 40
117514 4
118112 36

Friday, July 15, 2011 10:37:19 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Page 3

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Parent Item: D3686-041

Parent Item Name: MONOPOD ASSEMBLY

Start Date: 7/15/2011

Required Date: 7/22/2011

Start Qty: 2.00

Required Qty: 2.00

MS21043-3

Purchased

No

110

Each

872.0000

4

8



Nut



SB 11/07/19

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

800

112314

65

118077

735

8

NAS509L12C

Purchased

No

110

Each

23.0000

1

2



Nuts



SB 11/07/19

Location

Loc Qty

Loc Code

ST280

23

112314

13

112828

10

2

NAS509-12C

Purchased

No

110

Each

18.0000

1

2



Nuts



SB 11/07/19

Location

Loc Qty

Loc Code

ST280

18

112453

18

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

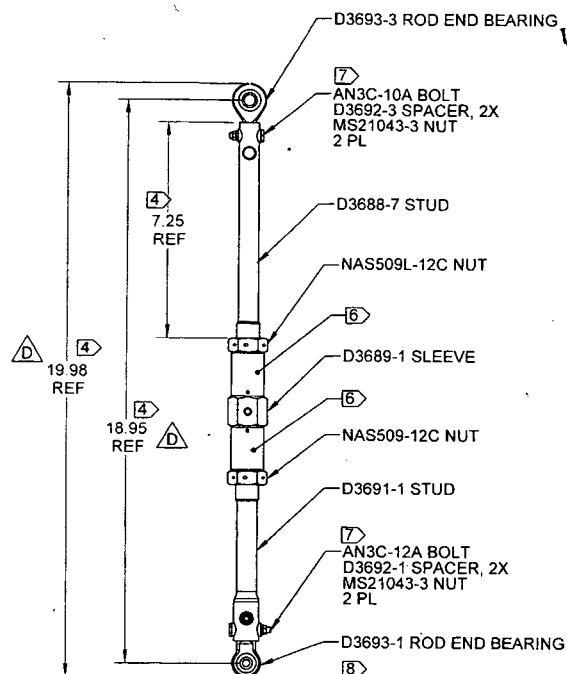
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ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3686-041	MONOPOD ASSEMBLY
2	1	D3688-7	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	4	D3692-3	SPACER
7	1	D3693-1	ROD END BEARING
8	1	D3693-3	ROD END BEARING
9	2	AN3C-10A	BOLT
10	2	AN3C-12A	BOLT
11	4	MS21043-3	NUT
12	1	NAS509L-12C	NUT
13	1	NAS509-12C	NUT



D3686-041 MONOPOD ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3686-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-7 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.0 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 & D3693-3 WITH D3688-7 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72001
PD 11-07-15

RELEASED
2010-03-15
JMS

D	19.98 WAS 20.10 (ZN C6-1); 18.95 WAS 19.07 (ZN C5-1)	RF	10.03.03
C	ROD END BEARINGS NOW ASSEMBLED USING SEALANT (ZN AB-1, B4-1)	RF	08.12.15
B	REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3686	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		MONOPOD ASSEMBLY	NTS
DATE	10.03.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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